



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3564-11
Job Sheet 173718



Part No: D3564-11

Job Qty: 14 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	3/29/18	3/29/18	0.00	0.00	Start Up Waterjet		ac 18/03/24
100	Waterjet	12 pcs	3/29/18	3/29/18	0.00	2.09	Waterjet1		ac 18/03/24
120	QC	12 pcs	3/29/18	3/29/18	0.00	0.00	QC8		38
130	Brake NC	12 pcs	3/29/18	3/29/18	0.38	0.80	Brake NC 1		9-88 SB
140	QC	12 pcs	3/29/18	3/29/18	0.00	0.00	QC5		
150	Autoweld 1	12 pcs	3/29/18	3/29/18	0.00	5.10	Automated welding		130 DAS
160	QC	12 pcs	3/29/18	3/29/18	0.00	0.00	QC10		38 DAS
170	QC	12 pcs	3/29/18	3/29/18	0.00	0.00	QC5		9-88 38
180	SprayPaint	12 pcs	3/30/18	3/30/18	0.00	1.20	Spray Paint		APR 12 2018
190	QC	12 pcs	3/30/18	3/30/18	0.00	0.00	QC5 QC3		APR 13 2018
200	Packaging	12 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3-1		APR 13 2018
210	QC21-SA	12 Ea	3/30/18	3/30/18	0.00	0.00	QC21		APR 13 2018

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: E Prog Rev: E 2-Deburr if necessary

Descriptions: 130 - Form on Brake as per Dwg D3564 using Jigs DT8179

150 - 1- AUTOWELD AS PER DWG AND QSI004 8259 HARDCOAT BATCH: _____

180 - APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG) 138842

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	16.9200 sf (1.41 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	17	133	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217		
2	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Setup ☐ Machining ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	MRB (QSI042) Approval			
Description Work Order		Completed By			
 Container No: S054594 Part: D3564-11 Job No: 173718 Serial No/Batch: S054594 Revision: _____ Inspector: _____		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			
		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:50%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			
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 www.dartaerospace.com

Date: 03/24/18

3	Wearshoe	2.500inches $\pm$ 0.010	2.510 2.490
4	Wearshoe	6.000inches $\pm$ 0.010	6.010 5.990
5	Wearshoe	12.104inches $\pm$ 0.010	12.114 12.094
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990
7	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970
8	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970
9	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470
10	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290
12	Wearshoe	0.188inches $\pm$ 0.005 - 0.001	0.193 0.187
13	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365
14	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053

Plex 3/6/18 1:12 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							